

Work Order ID 86739

86739

Page 1

July-06-12 11:48:51 AM

Item ID: D3025-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Beam
 Start Date: 7/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: K Date: 12079 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3025	B					4			

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control
 120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

Sm/B
12-7-24

DAS
16
9-8 12/10/24

4

B12-7-24

B12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3025-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Beam

Start Date: 7/06/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00 ***1***

Customer:


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Bend as per dwg NC BRAKE	0.00							
130									
Brake NC		0.00							
Brake NC	Memo								
									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish		0.00							
Hand Finishing	Memo								
150	QC3- Inspect Part Finish	0.00							
150									
QC		0.00							
Quality Control	Memo								

Sb 12/08/15

4

BY NB 12-8-16

12/8 /100P

W/O:		WORK ORDER CHANGES					
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 Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>177</u>	0.00	<u>5.1</u>	<u>3</u>		<u>12/08/16</u>			<u>40</u>
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

ML5 12/08/17
 ML5 12/08/16

W/O:		WORK ORDER CHANGES					
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Picklist Print

July-06-12 11:48:51 AM

Page 1

Work Order ID: 86739

Parent Item: D3025-1

Parent Item Name: Beam

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C01.10.26 Added Bending as per Drawing. SM IPP REV:D 11.05.16 MAT'L
THICKNESS CHG DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	213.4700	0.75	0.7894737	31	8/2-7-24	

Location

Loc Qty

Loc Code

MAT022

213.47

105411

6

109424

4

112331

3

113796

5

114025

10.7

116604

5.8

117392

19.1

118180

46

119117

25.7

120989

88.17

120 88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

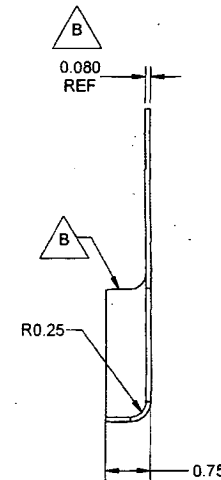
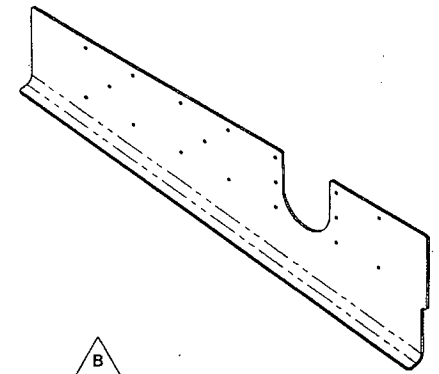
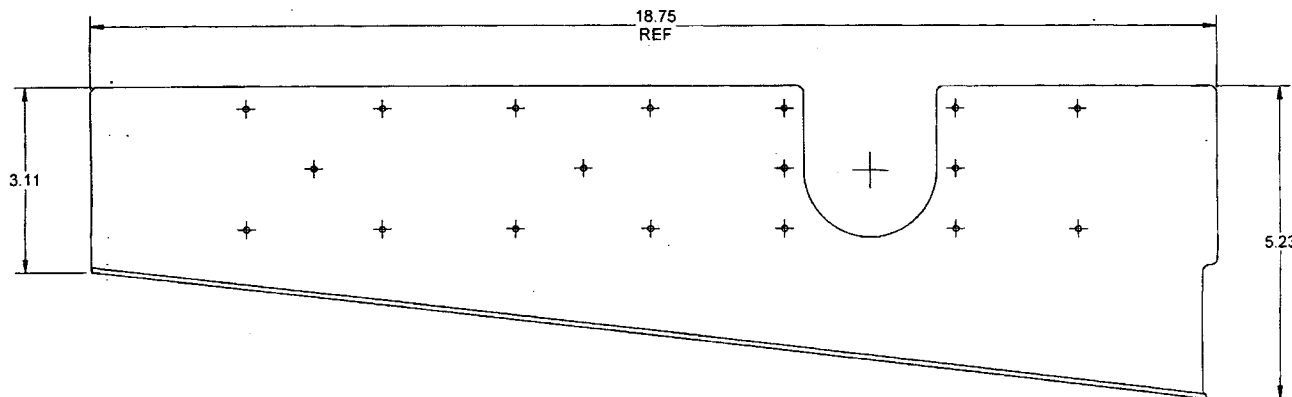
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86739 PL12-07-4



D3025-1 BEAM

NOTES:

- 1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs

RELEASED
2011-05-18

B	5.78 WAS 6.564 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3025	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BEAM	NTS
DATE	11.05.11	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 86739
Description: BEAM		Part Number: D3028-1
Inspection Dwg: D3028-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	± .004 - .007	.102	1		V B.C.2	
.25	± .02	.254	2		V	
.578	± .030	.5760	2		V	
3.00	± .030	2.999	2		V	
2.395	± .010	2.400	2		V	
1.385	± .010	1.387	2		V	
.375	± .010	.378	2		V	
2.332	± .010	2.330	2		V	
4.365	± .010	4.370	2		V	
4.18	± .030	4.683	2		V	
6.92	± .030	6.916	2		V	
7.235	± .010	7.239	2		V	
9.470	± .010	9.470	2		T Bol	
10.587	± .010	10.587	2		T	
11.705	± .010	11.705	2		T	
13.940	± .010	13.940	2		T	
15.057	± .010	15.057	2		T	
16.175	± .010	16.175	2		T	
18.75	± .030	18.75	2		T	
2.11						
1.080	± .010	.0803	2		V	

Measured by: MB	Audited by: SMB	Preliminary Approval:
Date: 12-7-24	Date: 12-7-24	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	